



Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3269-2**  
**Job Sheet 167432**



Part No: D3269-2

Job Qty: 6 Ea

Part Name: Bubble Window RH



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 10/31/17

Job Tracking No:

Created By: Victoria Michaud-Febrille

Due Date: 11/6/17

Description:

Type: SOLD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation  | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off      |
|-------|------------|-------|------------|----------|-----------|---------|-----------------------|-----------|---------------|
|       |            |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |               |
| 110   | Purchasing | 6 pcs |            | 11/6/17  | 0.00      | 0.00    | Purchasing            |           | 4T 11/6/17 30 |
| 140   | Packaging  | 6 pcs |            | 11/6/17  | 0.00      | 0.00    | Packaging2            |           | 11/6/17 30    |
| 150   | QC         | 6 pcs |            | 11/6/17  | 0.00      | 0.00    | QC6                   |           | 38            |
| 170   | Packaging  | 6 pcs |            | 11/6/17  | 0.00      | 0.00    | Packaging3            |           | 9-89          |
| 180   | QC21-SA    | 6 Ea  |            | 11/6/17  | 0.00      | 0.00    | QC21                  |           | 18/02/01      |

Part Op 110 - ISSUE P/O: \_\_\_\_\_ SUPPLIER: PLASTECB MANUFACTURE D3269-2 SUPER DWG C OF C  
Descriptions: IS REQUIRED

21  
9-89

FEB 02 2018

### Job Allocations

| Operation                              | Component Part | Required | Inventory | Allocated | Std Qty     |
|----------------------------------------|----------------|----------|-----------|-----------|-------------|
| 110-Purchasing                         | D3269-2P       | 6        | 0         | 0 DAS     | 0           |
| add unit'l. macrylics. 177 @ 12.5SF/pc |                |          |           | 13 9-89   | NOV 01 2017 |

### Part Specifications

Specifications could not be found.

Plex 10/31/17 1:18 PM dart.Michaud-Febrille.Victoria

master unit 000263



**S037072**



Bubble Window RH

**D3269-2**

**PART NO:**

**Serial #: S037072**

**Original**

**Revision:**

**Operation:**

**Change No:**

**Purchasing**

**Dart Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Mfg Date: 01/30/18  
Job No: 167432

|                                             |               |                             |
|---------------------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>                   |               | <b>Work Order:</b> 167432   |
| <b>Description:</b> Bubble Window, RH (R44) |               | <b>Part Number:</b> D3269-2 |
| <b>Inspection Dwg:</b> D3269                | <b>Rev:</b> E | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

| Description                                                     | Accept | Reject | Method of Inspection | Comments |
|-----------------------------------------------------------------|--------|--------|----------------------|----------|
| Depth of bubble within tolerances                               | /      |        |                      |          |
| Shape Definition                                                | /      |        |                      |          |
| Material imperfections such as bumps, cracks, voids, scratching | /      |        |                      |          |
|                                                                 |        |        |                      |          |
|                                                                 |        |        |                      |          |
|                                                                 |        |        |                      |          |

**Measured by:** EB **Date:** 18-01-31

#### TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 10.0              | +/-0.25   | 10.0             |        |        |                      |          |
| 6.2               | 0.036 Min | .074             |        |        |                      |          |
| 3.8               | 0.057 Min | .084             |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |

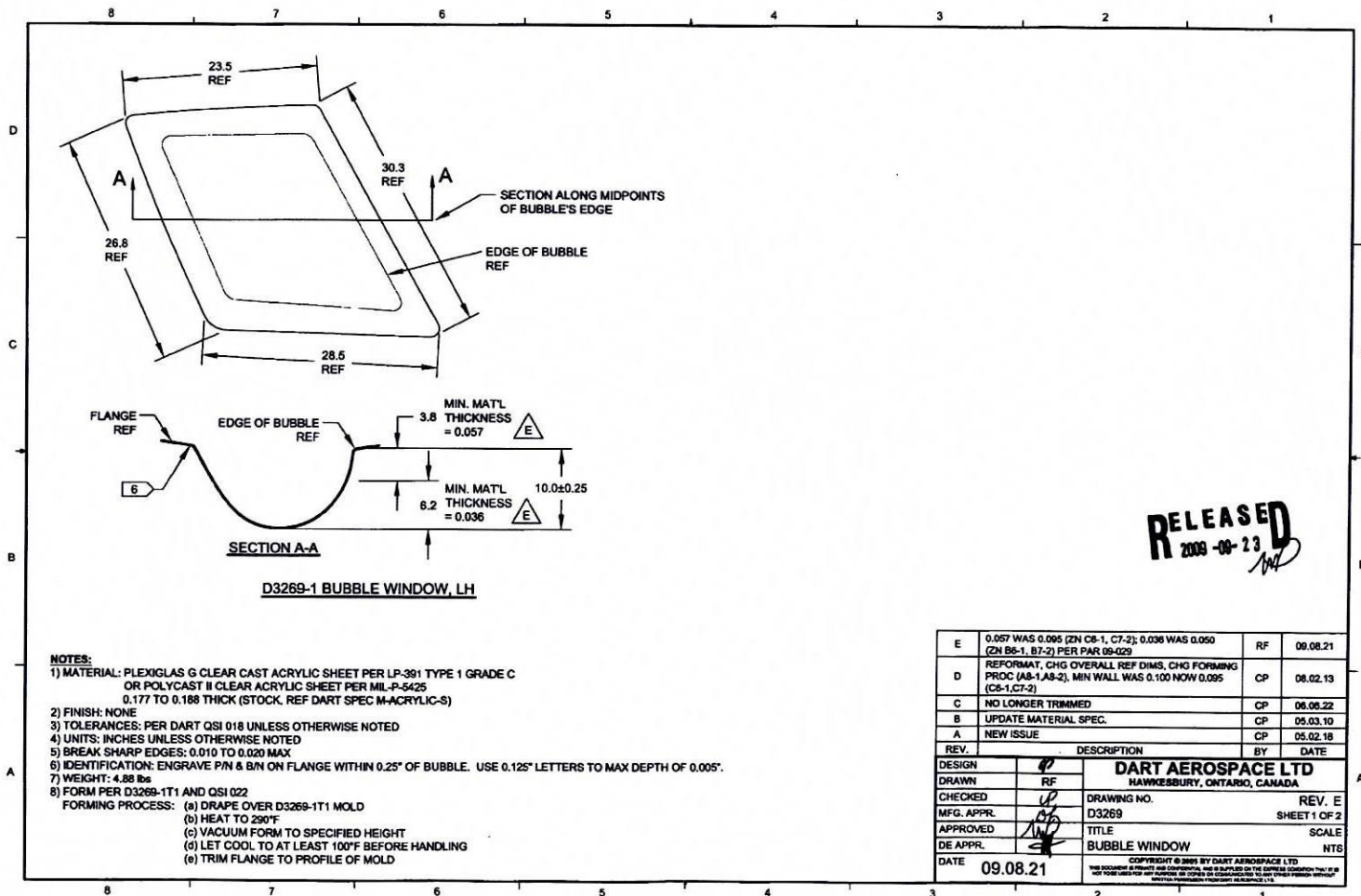
**Measured by:** **Date:**

**Audited by:** **Date:**

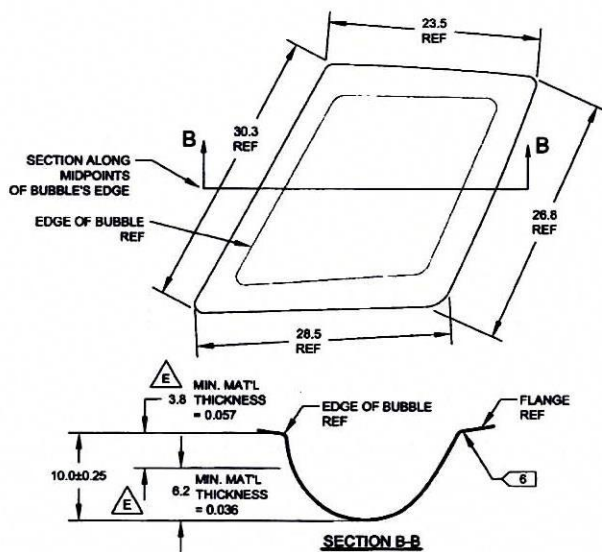
**Prototype Approval:** **Date:**

| Rev | Date     | Change                           | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A   | 08.11.27 | New Issue                        | KJ/DL      |          |
| B   | 09.10.16 | Tolerances revised per Dwg Rev E | KJ         |          |





8 7 6 5 4 3 2 1



D3269-2 BUBBLE WINDOW, RH

**RELEASED**  
2009-09-23

**NOTES**

- 1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 0.177 TO 0.188 THICK (STOCK, REF DART SPEC M-ACRYLIC-S)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
  - 6) IDENTIFICATION: ENGRAVE P/N & B/N ON FLANGE WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX DEPTH OF 0.005".
  - 7) WEIGHT: 4.88 lbs
  - 8) FORM PER D3269-2T1 AND QSI 022
- FORMING PROCESS: (a) DRAPE OVER D3269-2T1 MOLD  
(b) HEAT TO 290°F  
(c) VACUUM FORM TO SPECIFIED HEIGHT  
(d) LET COOL TO AT LEAST 100°F BEFORE HANDLING  
(e) TRIM FLANGE TO PROFILE OF MOLD

|            |          |                                                                                                                                                                           |              |
|------------|----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b>                                                                                                                                                 |              |
| DRAWN      | RF       | HAWKESBURY, ONTARIO, CANADA                                                                                                                                               |              |
| CHECKED    | RF       | DRAWING NO.                                                                                                                                                               | REV. E       |
| MFG. APPR. | RF       | D3269                                                                                                                                                                     | SHEET 2 OF 2 |
| APPROVED   | RF       | TITLE                                                                                                                                                                     | SCALE        |
| DE APPR.   | RF       | BUBBLE WINDOW                                                                                                                                                             | NTS          |
| DATE       | 09.08.21 | COPYRIGHT © 2008 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE FOR REPRODUCTION BY ANYONE<br>WHO HAS ACCESS TO THE INFORMATION CONTAINED HEREIN |              |

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO038215**

**Supplier:** PLA002-VC  
Plas-Tech  
115 Applewood Crescent  
Concord  
ON  
L4K 5C1 Canada  
Phone: 416-436-0004  
Fax: 416-736-0010

**PO No:** PO038215

**PO Date:** 11/1/17

**Due Date:** 1/26/18

**Purchase Order**

**Revision:**

**Revision Date:**

**Ship-To Contact:** Baker, Diane  
Phone: dbaker@dartaero.com

**E-MAILED**

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground

**Pymt Terms:** Net 30

**Freight Terms:**

**Special Comments:**

*REVISED*

## **Items**

| Line Item | Part     | Supplier Part No | Item No | Description           | Status | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
|-----------|----------|------------------|---------|-----------------------|--------|----------|----------------|-------------------|---------|------------------|----------------|
| 1         | D3269-2P |                  |         | Bubble Window, RH R44 | Firmed | 1/26/18  | 5 pcs          | 0 pcs             | 5 pcs   | \$300.00/pcs     | \$1,500.00     |

**Line Item Note** As Per Dwg D3269 Rev. E+  
job# 167432

**Grand Total:** \$1,500.00

## **Order Notes**

### **Procurement Quality Clauses**

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 1/16/18 2:14 PM dart.lavoie.chantal

# Packing Slip



115 Applewood Crescent  
Concord, ON, L4K 5C1  
PLASTECHONLINE.COM  
P- 416 736 0004  
F- 416 736 0010

Shipment Number: 26670  
Shipment Date: 01/25/2018  
BOL Number:  
Customer Key: C1887  
Salesperson: MIKE AUBE  
Page Number: 1 of 1

B DART AEROSPACE LTD.  
I 1270 ABERDEEN STREET  
L HAWKESBURY ON K6A 1K7  
L CA  
T Attn: DALE  
O

S DART AEROSPACE  
H 1270 ABERDEEN STREET  
I HAWKESBURY ON K6A 1K7  
P CA  
T Attn: ROBERT ABOUD  
O

Purchase Order  
38215  
Carrier Account #

Sales Order  
SO-021020

Ship Via  
FREIGHTCOM INC. -

Incoterms  
EX WORKS

Payment Method  
PPD/CHG  
Tracking Number

Item Number - Revision Description

D3269-2P - Rev.: E

BUBBLE WINDOW, RH, R44

AS PER DWG D3269

HS Code: 3920.51.1000 - OTHER

Country of Origin : CA

Quantity UOM  
Shipped

5 EA

AT 18/01

1 EA

FREIGHT -

FREIGHT

Number of Containers

Gross Weight

Shipped By



# Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 38215 SO # 021020

|             |                        |                |       |         |         |
|-------------|------------------------|----------------|-------|---------|---------|
| Part #      | D3269-2P               | Qty.           | 3     | Batch # | -001    |
| Description | BUBBLE WINDOW, RH, R44 | Material usage | 1 SHT | Lot#    | M135555 |
| Part #      | D3269-2P               | Qty.           | 2     | Batch # |         |
| Description | BUBBLE WINDOW, RH, R44 | Material usage | 1 SHT | Lot#    | 122537  |
| Part #      |                        | Qty.           |       | Batch # |         |
| Description |                        | Material usage |       | Lot#    |         |
| Part #      |                        | Qty.           |       | Batch # |         |
| Description |                        | Material usage |       | Lot#    |         |
| Part #      |                        | Qty.           |       | Batch # |         |
| Description |                        | Material usage |       | Lot#    |         |
| Part #      |                        | Qty.           |       | Batch # |         |
| Description |                        | Material usage |       | Lot#    |         |
| Part #      |                        | Qty.           |       | Batch # |         |
| Description |                        | Material usage |       | Lot#    |         |
| Part #      |                        | Qty.           |       | Batch # |         |
| Description |                        | Material usage |       | Lot#    |         |

Note: All parts are not identified as meeting QSI044.

By: AS  
(Approved QA Signatory)

Date: JAN. 26, 2018 C O F C # 030

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com